

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024272**Date Inspected:** 05-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 13CW to Segment 14AW (Edge Beam to Edge Beam)

This QA Inspector performed Dimension Control Inspection on the Edge Beam to Edge Beam at Work Point W4 (Cross Beam side) for the Segment 13CW to Segment 14AW between Panel Point (PP) 124.5 to PP 125 at the following locations:

The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The Sweep was measured at 100 mm from both sides of the Floor Beam and 800mm from both sides of floor Beam and at Center (Total 5 Locations) using string line.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

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## WELDING INSPECTION REPORT

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Segment 13CW to Segment 14AW (Root Gap and Offset)

This QA Inspector performed Dimension Control Inspection for measuring Root Gap and Offset at the Transverse Splice for the Segment 13CW to Segment 14AW between Panel Point (PP) 124.5 to PP 125 at the following locations:

Work Point W5 towards Work Point W16, at 5 locations (Edge Panel Cross Beam side).

Work Point W16 towards Work Point W14, at 17 locations (Side Panel, Cross Beam side).

Work Point W14 towards Work Point W4, at 6 locations (Bottom Panel, Cross Beam side).

Work Point W4 towards Work Point W3, at 18 locations (Bottom Panel).

Work Point W3 towards Work Point W13, at 21 locations (Bottom Panel, Counter Weight side).

Work Point W13 towards Work Point W17, at 5 locations (Side Panel Counter Weight Side).

Work Point W17 towards Work Point W19, at 7 locations (Edge Panel Counter Weight Side).

Work Point W20 towards Work Point W5, at 47 locations (Deck Panel).

The QA Inspector measured the root gap using 1(One) taper gauge and measured the offset using a bridge cam gauge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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